



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3179-041
Job Sheet 171543



Part No: D3179-041

Job Qty: 6 ea

Part Name: Litter Tie Down (Non-Locking)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/2/18

Job Tracking No:

Due Date: 2/15/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E IPP A1 03.01.09 Added Acid etch end alodine RF IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP REV:C AS PER REV D JLM 13-05-24 VERIFIED BY:DD IPP Rev:C 08-12-10 add part list DD verified
by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	2/14/18	2/14/18	0.00	0.00	Start Up Machining-1		J.L. 18/02/04
100	Bandsaw	6 pcs	2/14/18	2/14/18	0.00	0.50	Bandsaw1		J.L. 18/02/04
110	CNC Vertical Machining	6 pcs	2/14/18	2/14/18	0.37	10.91	HAAS1-3		J.L. 18/02/03
120	QC	6 pcs	2/14/18	2/14/18	0.00	0.00	QC2 Machining-1		J.L. 18/02/03
130	QC	6 pcs	2/14/18	2/14/18	0.00	0.00	QC8 Machining-1		J.L. 18/02/03
140	HandFinish	6 pcs	2/14/18	2/14/18	0.00	0.49	HandFinish1		18-02-05
150	QC	6 pcs	2/14/18	2/14/18	0.00	0.00	QC7-2		18-02-05
160	Powdercoat	6 pcs	2/14/18	2/14/18	0.00	0.36	Powdercoat1		18-02-05
170	QC	6 pcs	2/14/18	2/14/18	0.00	0.00	QC3		18-02-05
180	Small Fab	6 pcs	2/15/18	2/15/18	0.00	0.89	Small Fab-3		18-02-05
190	QC	6 pcs	2/15/18	2/15/18	0.00	0.00	QC5		18-02-05
200	Packaging	6 pcs	2/15/18	2/15/18	0.00	0.00	Packaging3-1	5.225	18-02-05
210	QC21-SA	6 Ea	2/15/18	2/15/18	0.00	0.00	QC21		18-02-05

Part Op 100 - Cut blanks: 12.150" long

Descriptions: 110 - 1- Mill as per Folio FA297 Rev: 2A & Dwg D3179-1 Rev: E

160 - START TIME: 3:25

180 - Assemble as per Dwg D3179

→ Drill Holes #10 .246
M188467. START: 3:25 O.K.T. 3:30 FINISH: 3:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2372	Quick Release	GA 12 Ea (2 ea)	90-Start up Operation	F164839
D2444	Pip Pin Assembly	GA 6 Ea (1 ea)	90-Start up Operation	5027862
D6201	T Extrusion	6.0750 ft (1.0125 ea)	90-Start up Operation	
MS21042L3	Nut	303 6 Ea (1 ea)	90-Start up Operation	5037284-1
MS27039-1-13	Screw	280 6 Ea (1 ea)	90-Start up Operation	F125654
NAS1149D0332J	Washer	260 18 Ea (3 ea)	90-Start up Operation	5020606

5031422 + 5038638 - 5038760

DART
AEROSPACE
S038700

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Litter Tie Down (Non – Locking)

PART NO: D3179 – 041

Original Serial #: S038700

Revision:

Operation: Start up Operation 02/04/18

Change No:

Job No: 171543

DART AEROSPACE LTD		Work Order:	
Description: Fwd Litter Tie Down Bracket		Part Number:	D3179-1
Inspection Dwg: D3179 Rev: E		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.00				
R0.40	+/-0.030	R0.40				
R0.38	+/-0.030	R0.38				
1.70	+/-0.030	1.70				
Ø0.191	+0.005/-0.001	0.191				
10.500	+/-0.010	10.500				
4.250	+/-0.010	4.249				
Ø0.246	+0.005/-0.001	0.245				
1.50	+/-0.030	1.50				
0.750	+/-0.010	0.749				
1.000	+/-0.010	1.000				
4.00	+/-0.030	4.001				
1.00	+/-0.030	.993				
1.38	+/-0.030	1.378				
1.875	+/-0.010	1.875				
2.125	+/-0.010	2.125				
2.88	+/-0.030	2.88				
3.31	+/-0.030	3.31				
R0.375	+/-0.010	R0.375				
R0.50	+/-0.030	R0.5				
Ø0.191	+0.005/-0.001	0.191				
R0.25	+/-0.030	R0.250				
R0.375	+/-0.010	R0.375				
R0.38	+/-0.030	R0.38				
12.00	+/-0.030	12.00				
9.000	+/-0.010	9.000				
7.50	+/-0.030	7.50				
4.50	+/-0.030	4.50				
2.88	+/-0.030	2.875				
2.250	+/-0.010	2.249				
1.000	+/-0.010	.999				
0.50	+/-0.030	.497				

Measured by: SC.	Checked by: gmk	QC Inspector:
Date: 18/02/04	Date: 18/02/05	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue P/O D3179-041	KJ/DD	
B	12.10.04	Dimension 0.750 was 1.750	KJ	
C	13.05.27	Dimensions revised per Dwg Rev D	KJ	
D	16.06.08	Dimensions revised per Dwg Rev E	KJ	
E	17.02.16	Dimensions rearranged	KJ	